

ASAP

Dart Aerospace Ltd.

Date: Monday, 21/07/2008 10:53:27 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT  
 Job Number : 40682  
 Estimate Number : 10981  
 P.O. Number :  
 This Issue : 21/07/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2565307  
 First Issue : 1/1 Type : SMALL / MED FAB Drawing Number : D2565 REV E  
 Previous Run : 26642 Project Number : N/A  
 Drawing Revision : E  
 Material :  
 Due Date : 10/08/2008 Qty: 5 Um: Each  
 Written By :  
 Checked & Approved By : JUL 08.7.21  
 Comment : Est:A 02.06.10 New Issue NG

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 1.8462 f(s)/Unit Total : 9.2311 f(s)  
 Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall  
 (M304TR0750W049) Batch No: M108846

SB 08/08/20 (5)

2.0 BRAKE NC NC BRAKE



PTU →

Comment: BRAKE NC  
 Punch as per Dwg D2565 using DT 8313

SB 08/08/20 (5)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

SB 08/08/26 (5) HN

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/08/09 (5)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
 Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50  
400  
2:20

M. 08/09/08

(5X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565-307 PAR #: W/A Fault Category: Prod / Ins. ass. mod & Small NCR: Yes No DQA: D Date: 08/09/05  
D205-638- QA: N/C Closed: D Date: 08/09/05

NCR: <u>40682</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
03.03.27	2	Dimension 20.06 is out of tolerance (all 5 parts) Root Cause: Tape measure used for mts. is <del>out of tolerance</del>	<u>PH</u> 03.03.27 053042	- Recommend to cutoff <del>one</del> 1 end and reuse part on shorter strut - Destroy tape measure	<u>PH</u> 08/08/28	<u>S</u> 08/08/29	<u>PH</u> 08.09.22 053042	<u>S</u> 08/08/27
		not reading correctly. It has two small kinks: employee was measuring of the 10" line		that is out of tolerance D2565-109 B 411605 used on.				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40682

Part Number: D2565307

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT

08-09-02

KS

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 253

JS

08/09/02 KS

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/03 JS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

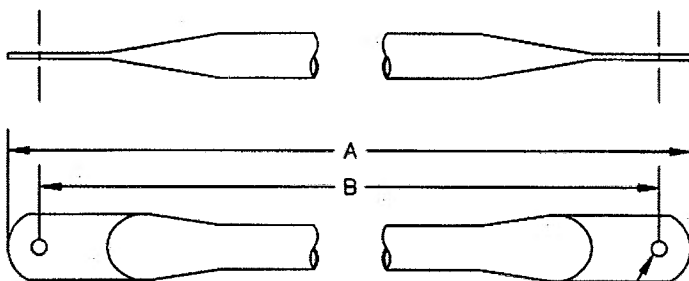
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED  
04.05.05



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY  
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

20.196

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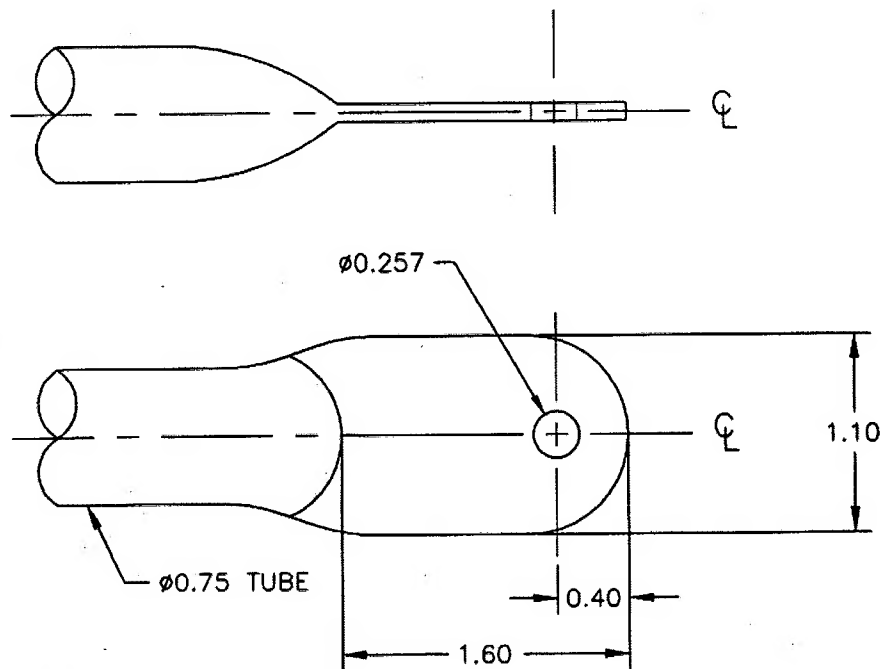
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED  
98/05/05 KE

SPECIFICATION CONTROL DRAWING  
FOR PUNCH DT8117



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